



**GET BACK TO...
WORK**

"We need to throw as many parts at this as possible"

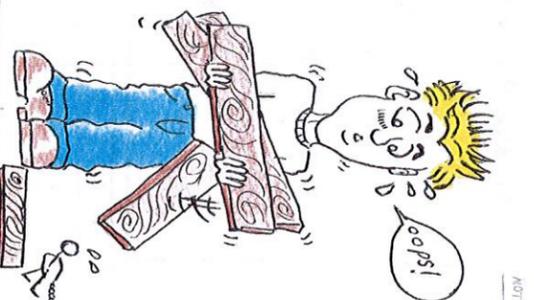
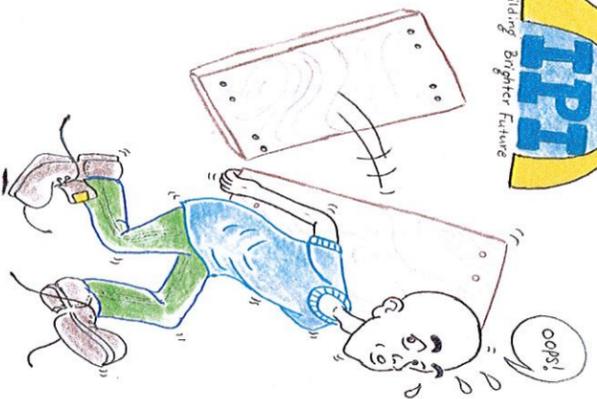
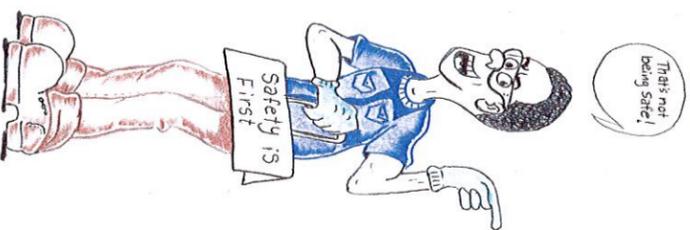
ZONE 1



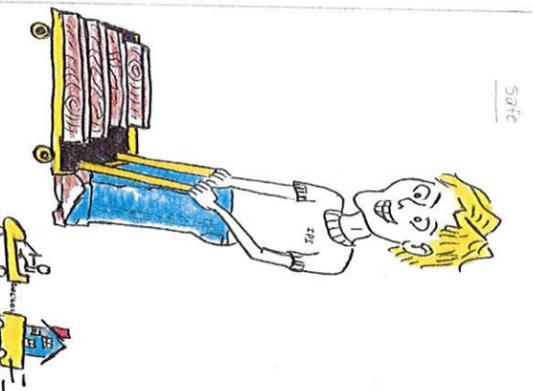
Past State- 9 beds per day

Telling your workers you need 20 beds a day.

LEAN BY-WAY OF SAFETY



NOT SAFE



SAFE



- Several carts for production eliminated, creating usable space.
- 8 separate processes turned into 1 continuous process.
- Smaller batch sizes. Turned weekly batches into daily batches.
- If daily goals were not met we assigned counter-measures to fix any issues

5S AUDITS

DAILY METRICS MEETINGS

KEEPING EMPLOYEES INFORMED

- Order Tracking became much easier with standard daily numbers.
- Visual Management was non-existent. Assigned carts to specific areas. Easy to detect problems if cart was missing.
- Eliminated a lot of WIP. Machines were not backed up with material sitting on carts that were taking up valuable floor space.
- Eliminated half of the carts being used to transport material.



OUR GOAL = 20 BEDS/ DAY

A lot needed to change to obtain this goal. We began by eliminating carts of built up product in different areas that were getting backed up. Using 5S we were able to get rid of a lot of unnecessary items, and create a normal for the areas for visual management. We began to fill the pipeline with 20 bed a day product in every area. So when that process moved, the product before it and after it were also ready to move creating flow.